

Work Order ID 120290

July-10-14 9:00:37 AM

*Report*

\*120290\*

Page 1

Item ID: D2353 Accept \*N9000040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Stiffener  
 Start Date: 6/04/14 Start Qty: 30.00 \*30\* Cust Item ID:  
 Required Date: 6/04/14 Req'd Qty: 30.00 \*30\* Customer:  
 Reference:

Approvals: Process Plan: *[Signature]* Date: Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2353	Rev C								

100 FLOW WATER JET 0.00  
 \*100\*  
 Waterjet Memo 0.00  
 FLOW CNC Waterjet 1-Cut as per Dwg D2353 Dwg Rev: C Prog Rev: C 2-  
 Deburr if necessary

(27) mm 14/07/15

110 QC2- Inspect parts off machine FAI/FAIB 0.00  
 \*110\*  
 QC Memo 0.00  
 Quality Control

(27) mm 14/07/15

120 QC8- Inspect parts - second check 0.00  
 \*120\*  
 QC Memo 0.00  
 Quality Control

DAS 27 \$-09  
 27

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July-10-14 9:00:37 AM

**\*120290\***

Page 2

Item ID: D2353 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Stiffener  
 Start Date: 6/04/14 Start Qty: 30.00 **\*30\*** Cust Item ID:  
 Required Date: 6/04/14 Req'd Qty: 30.00 **\*30\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> Brake NC Brake NC	NC BRAKE  Memo Bend per Dwg D2353	0.00  0.00		DAS 30 9-89		27			14/09/16
140 <b>*140*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00		68-6 27 DAS 4/11/17		27			
150 <b>*150*</b> HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00		PLM 14-07-22					



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July-10-14 9:00:37 AM

Page 4

Item ID: D2353 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Stiffener  
Start Date: 6/04/14 Start Qty: 30.00 **\*30\*** Cust Item ID:  
Required Date: 6/04/14 Req'd Qty: 30.00 **\*30\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location: _____	0.00							
<b>*180*</b>									DAS
Packaging	Memo	0.00							32
Packaging	ST 206								9-89
190	QC21- Final Inspection - Work Order Release	0.00							
<b>*190*</b>									
QC	Memo	0.00							
Quality Control									

17/7/27 27

MCS 1407-24

ME  
14-7-27

# Picklist Print

July-10-14 9:00:37 AM

Page 1

Work Order ID: 120290

\*120290\*

Parent Item: D2353

\*D2353\*

Parent Item Name: Stiffener

Start Date: 6/04/14

Required Date: 6/04/14

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP Rev: A Removed from 9 Digit 05-11-10 EC  
IPP: B 06.11.15 waterjet EC  
IPP: c 06.12.07 ecn 836 ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.050		Purchased	No			100	sf	114.1911	0.1463	5			

\*M2024T3S 050\*

2024-T3 .050 sheet

\*\*

mm 17/07/15

Location

Loc Qty

Loc Code

MAT022

114.1911

124643

53.7911

m128354

48

m128713

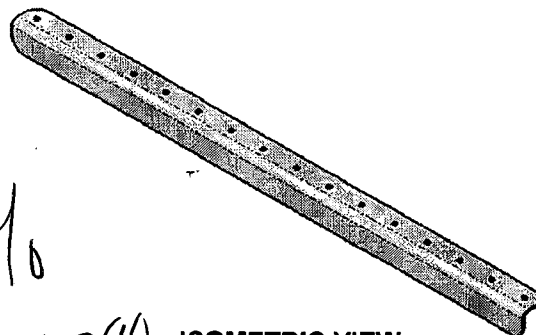
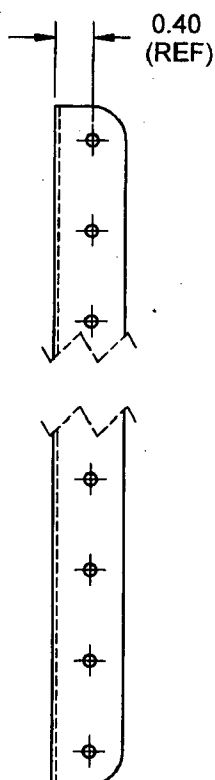
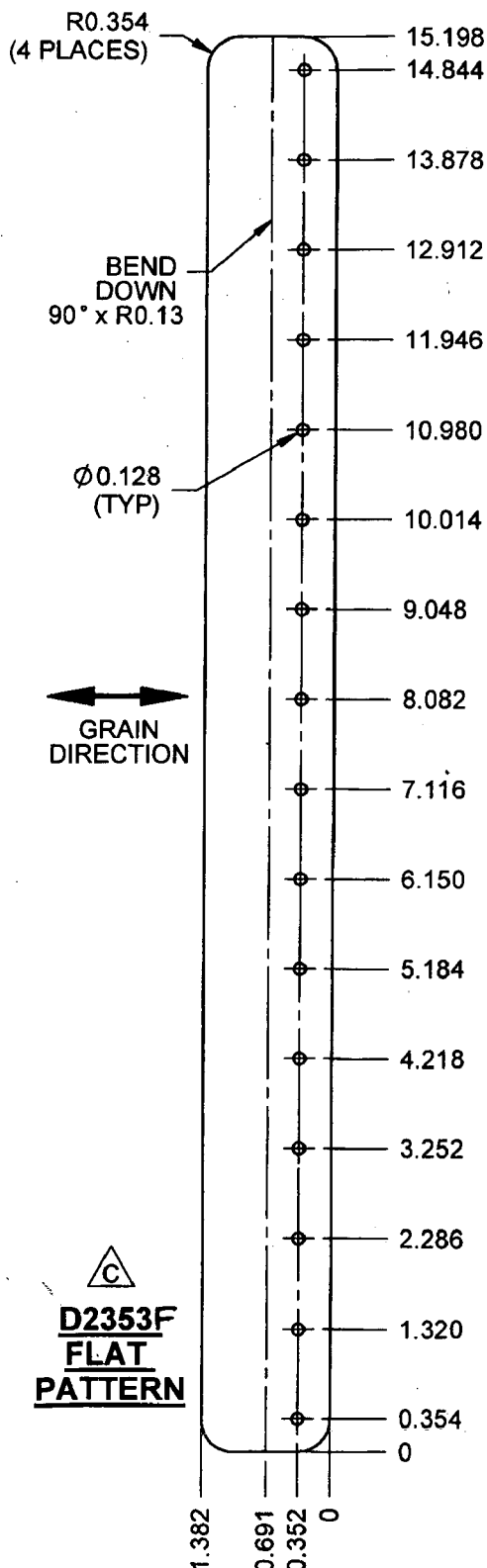
12.4

5.6



**DART**

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED <i>[Signature]</i>	DRAWING NO. D2353	REV. C SHEET 1 OF 1
DATE 06.11.13		TITLE STIFFENER	SCALE 1:2
REV	DATE	DESCRIPTION	
B	95.02.23	ADD TEXT	
C	06.11.13	ADD FLAT PATTERN; ADD NOTES; UPDATE DWG	



ISOMETRIC VIEW  
SCALE 1:4

NOTES:

- 1) MATERIAL: ALUMINUM 2024-T3 SHEET, 0.050 THICK  
PER QQ-A-250/4 OR AMS 4037  
(REF DART SPEC M2024T4S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT  
PER DART QSI 005 4.1  
POWDER COAT BLACK SANDTEX (4.3.5.7)  
PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D2353" USING A WHITE  
FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS  
OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

**D2353F  
FLAT  
PATTERN**

**D2353  
BEND DETAIL**

RELEASED

06.11.28

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